

Work Order ID 58090

April 22, 2010 2:55:51 PM



Page 1

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-4-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

2 - - AWM 10-04-27

101

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 4/10/30

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□□

A/R Sikaflex-291 batch: 112429 □□□

Sikaflex expire date: 10-02-20

Start time: _____ bond for 12hrs

9:30

2 - - AWM 10-5-4

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP 10-5-4 (2)

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April 22, 2010 2:55:51 PM



Page 3

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Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Identify as per dwg & Stock Location: 46

0.00



10-5-4

2

Memo

0.00

Packaging

150



QC

QC21- Final Inspection - Work Order Release

0.00

10/05/04

Memo

0.00

Quality Control

ME

10-5-4

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Picklist Print

April 22, 2010 2:55:55 PM

Page 1

Work Order ID: 58090

Parent Item: D2580-1

Parent Item Name: 205 Skidtube bent detail


Comments: IPP B001.11.08 Revised Step 9, 10, 12, and 13 SM

Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190  Ext'n -I Beam Tube 4"		Manufactured	No				Each	56.0000	2.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

52319

56

56

110

Each

2.0000

2.0000



AWM 10-05-01 (2)

D2596



Web, 205 Skidtube

Manufactured

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

8

Main Warehouse

LG46

2

57540

2

B-58227

AWM 10-05-01 (2)

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58090
BS-0-4-22

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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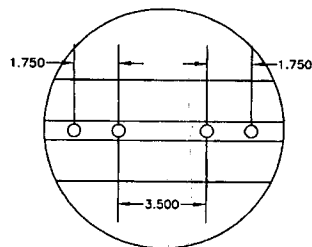
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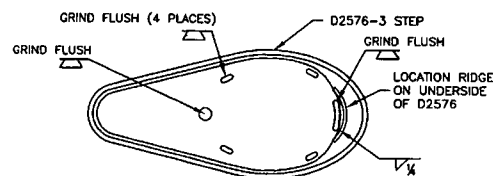
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

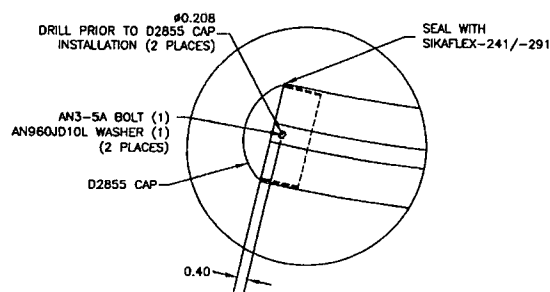


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07 de 28-4

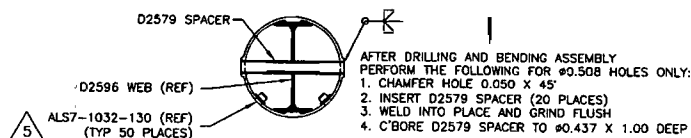
DETAIL B
SCALE 5:24



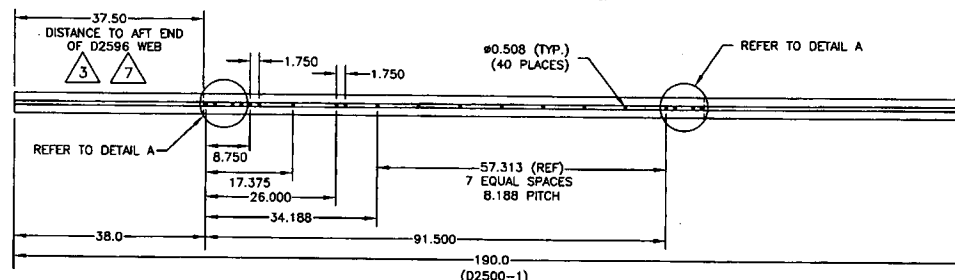
DETAIL C
SCALE 5:24



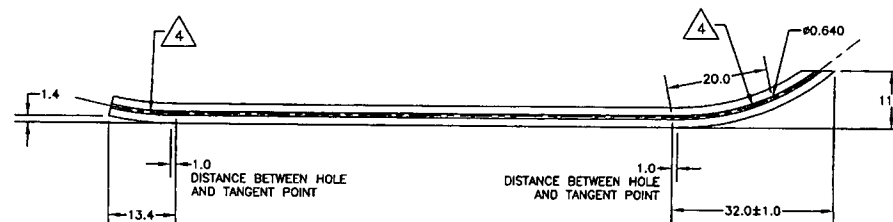
SECTION D-D
SCALE 5:24



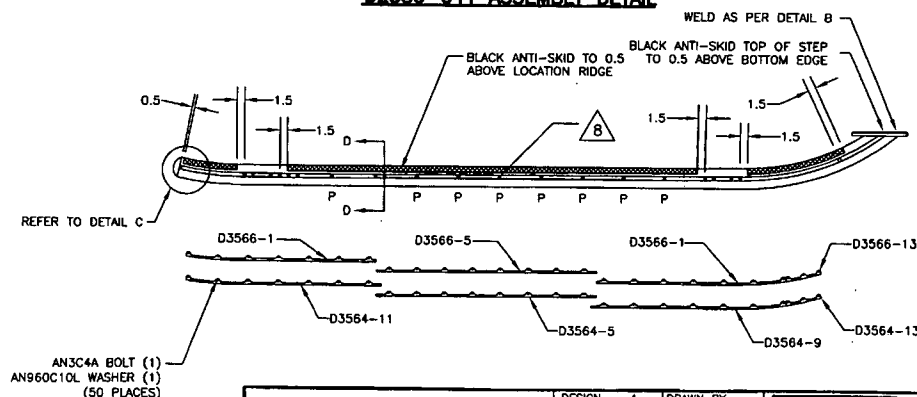
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DATE		DRAWING NO.		REV. D
07.02.27		D2580		SHEET 2 OF 3
		TITLE		SCALE
		205 SKIDTUBE ASSEMBLY		1:24

W/O:		WORK ORDER CHANGES					
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97-16-28

DETAIL F
SCALE 5:24

GRIND FLUSH (4 PLACES)

GRIND FLUSH

D2576-3 STEP

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/8"

Diagram of a circular web with labels:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF)
(TYP 50 PLACES)

Diagram showing a circular web with a central cross-section. A horizontal line is labeled D2579 SPACER. A vertical line is labeled D2596 WEB (REF). A small square is labeled ALS7-1032-130 (REF) (TYP 50 PLACES). A list of steps is provided:

1. CHA
2. INS
3. WE
4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2598 WEB

3
7

1.750 1.750

Ø0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH


38.0

91.500

190.0
(D2500-1)

Figure 1 is a plan view of the proposed road layout. It shows the alignment of the road, the location of the existing road, and the proposed road. The diagram includes dimensions for the road width, the distance between the road and the existing road, and the location of the road relative to the existing road. Key dimensions include 51.340, 39.580, 5.915, 5.985, 1.4, 5.338 (REF), 3.630 (REF), 0.508 (8 PLACES), 20.0, 0.640, 11, 1.0, 13.4, 32.0 ± 1.0, and 1.0. A note indicates "DISTANCE BETWEEN HOLE AND TANGENT POINT" for two locations.

[illegible]

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	CHECKED <i>HF</i>	APPROVED <i>HF</i>		DRAWING NO. 02580
	DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

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